

# Work Order ID 61541

Monday, August 30, 2010 10:39:10 AM



Page 1

Item ID: D206-559-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 8/30/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*H*

Date: 10-8-30 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D206-559

~~PRELIM~~ Rev 14

P10 →

100 ~~DS7 9507~~

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPPD206-559-011 CHG00

*7 per cen.  
10-6-13  
mf  
10-9-15*

*JG dar BG 10-10-07*

*Sokoliz*

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*C10/10/12 (4)*

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*Sokoliz*

*(74)*

Dart Aerospace Ltd

W/O: 61541		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/10/12	100	Perm. Change update - header box to current Rev + Add DSE. Fix CHG # PER EN 10-613	EE	10/10/12			S 10/10/12

Part No: D206-559-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 61541**

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Item ID: D206-559-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw

Start Date: 8/30/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-011 □ Location: 11

190

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

10/10/13

10/10/13

MF  
10-10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, August 30, 2010 10:39:15 AM

Page 1

Work Order ID: 61541

Parent Item: D206-559-011

Parent Item Name: Bearpaw

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C 04.02.17 Blank size changed KJ/JLM  
 IPP Rev:D 07-01-02 Was K10007 JLM  
 IPP Rev:E 08-05-05 up a chg DD verified by:EC  
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A 20A per 5579527  
 8/10/12 Purchased

Bolt

Location	Loc Qty	Loc Code
ST	112	
115374	112	
ST338	112	
ST358	263	
114784	21	
115108	142	
115371	100	

AN4-17A Purchased

Bolt

Location	Loc Qty	Loc Code
ST359	536	
112314	536	

AN960JD416 NAS1149D0463J Purchased

Washer

M112314

164

M115697

11/14/12 (4)

W/O: 61541		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/10/12	100	Perm. change update to DS7 9527 with to remove ANY-15A Bolts and replace with ANY-20A Bolt qty x 8 per kit	CE	10.10.13			10/10/12

Part No: D206-559-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Monday, August 30, 2010 10:39:15 AM

Page 2

Work Order ID: 61541

Parent Item: D206-559-011

Parent Item Name: Bearpaw

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 4.00

Required Qty: 4.00

D2182B

Manufactured No

160 f

215.1285

1.666

6.664



Rubber Cushion



B 454.5 4.00

## Location

## Loc Qty

## Loc Code

ST402A

26.07

30872

13.67

39986

12.4

ST410

189.05854

52649

189.05854

52649 2-17

(D2182B050) Cut (4) at 5.00" as per dwg \*\*\*per kit\*\*\*

D2274

Manufactured No

160 Each

168.0000

8

32



Radius Block



51427 12X

## Location

## Loc Qty

## Loc Code

ST010

168

59108

168

52649 4X  
54850 8X  
59108 8X

D2435

Manufactured No

160 Each

0.0000

2

8



Bearpaw, 206



B 61536

D2438

Manufactured No

160 Each

228.0000

4

16



Clamp



B 52649 11X

## Location

## Loc Qty

## Loc Code

ST456

228

59123

28

60852

200

59123 5X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Parent Item: D206-559-011

Parent Item Name: Bearpaw

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 4.00

Required Qty: 4.00

D2529  
Washer

Manufactured No

160 Each

166.0000 8 32



B 52745 12 X

*[Signature]*

Location

Loc Qty

Loc Code

ST017

166

58568

166

58568 20 X  
32 ✓

*[Signature]*

MS21042L4  
Nut

Purchased No

160 Each

2,527.000 8



Location

Loc Qty

Loc Code

ST300

2527

113422

68

114523

28

114718

16

114784

495

115108

1920

M 115108  
8 ✓

*[Signature]* 10/14/12 (4)

QS200-M44S  
Clamp

Purchased No

160 Each

32.0000 2



Location

Loc Qty

Loc Code

ST450

32

114917

12

115410

20

114917

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY

5.0 PARTS LIST (D206-559 REV. K)  
32.7 PARTS LIST (ICA-D205-559 REV. 2)






Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 10.06.30  
CERT. NO.: SH92-17  
ISSUE NO.: 7

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
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